

Work Order ID 69758

Wednesday, May 18, 2011 1:00:57 PM



Page 1

| | | | | | | |
|----------------|-----------|------------|-------|-------|---------------|--|
| Item ID: | D2012-113 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Clamp | | | | | |
| Start Date: | 5/18/2011 | Start Qty: | 20.00 | | Cust Item ID: | |
| Required Date: | 5/23/2011 | Req'd Qty: | 20.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | | | | | |
|------------|---------------|--|-------|----------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | | Date: | 11-05-10 | Tooling: | | Date: | | Run | Start | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2012-113 | Rev C | | | | | | | | |
| 100 | FLOW WATER JET | 0.00 | | | | | | | |
| | Waterjet | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg D2012-113 | | | | | | | | |
| 304 . 063 | Dwg Rev: <u>C</u> | | | | | | | | |
| | Prog Rev: <u>C</u> | | | | | | | | |
| | 2-Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

B11-5-26

30

B11-5-26

5 11/05/27

counts
x30

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 69758

Wednesday, May 18, 2011 1:00:57 PM



Page 2

Item ID: D2012-113

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 5/18/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 Small Fab | Small Fab | 0.00 | | | | | | | |
| Small Fab | Memo | 0.00 | | | | (30) | | | |
| Small Fab | 1- Deburr any rough edges 2- Bend as per Dwg D2012-113 using DT8458 3- Tumble | | | | | | | | |
| | | | | | | | | | |
| 140 QC | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | (30) | | | |
| | | | | | | | | | |
| 150 Packaging | Identify as per dwg & Stock Location | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| | | | | | | | | | |

SB 11/6/07

8.11/6/09

count

11-6-9

(30)

11/6/5 (30)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 69758

Wednesday, May 18, 2011 1:00:57 PM

Page 3

Item ID: D2012-113

Accept

Setup Start

Revision ID:

Stop

Item Name: Clamp

Start Date: 5/18/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/13

mf

11-06-12

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 18, 2011 1:01:02 PM

Page 1

Work Order ID: 69758

Parent Item: D2012-113

Parent Item Name: Clamp



Start Date: 5/18/2011

Required Date: 5/23/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: F01.10.05 Fixed Typo and Added Inspection Level 21 SM
IPP Rev:G Now on Waterjet 07-03-28 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S16GA

Purchased

No

110

sf

194.8000

0.015

0.315789

15



B11-5-26

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

194.8

117275

34.8

117653

160

117653

30

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

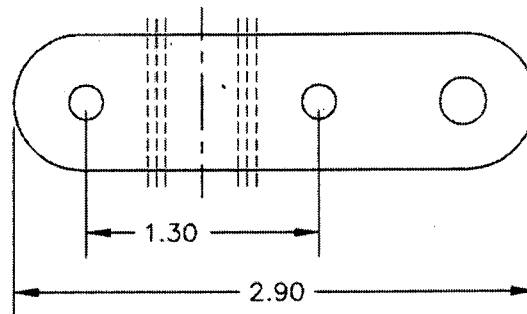
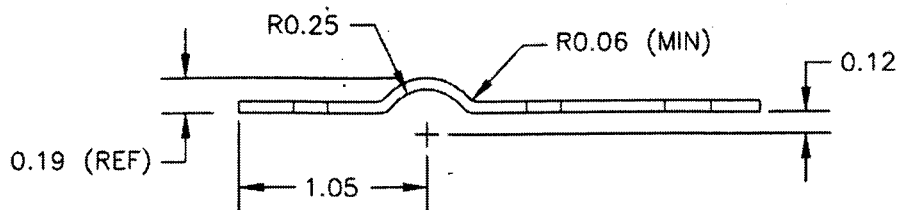
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN JB | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2012-113 | REV. C SHEET 1 OF 1 |
| DATE 00.04.28 | TITLE CLAMP | | SCALE 1:1 |
| A | 92.06.03 | REDRAWN FROM D2012 | |
| B | 00.02.23 | REDRAWN; R0.38 WAS R0.50; Ø0.191 WAS Ø0.189; ADDED FLAT PATTERN | |
| C | 00.04.28 | 2.96 WAS 3.35; 1.360 WAS 1.745 | |

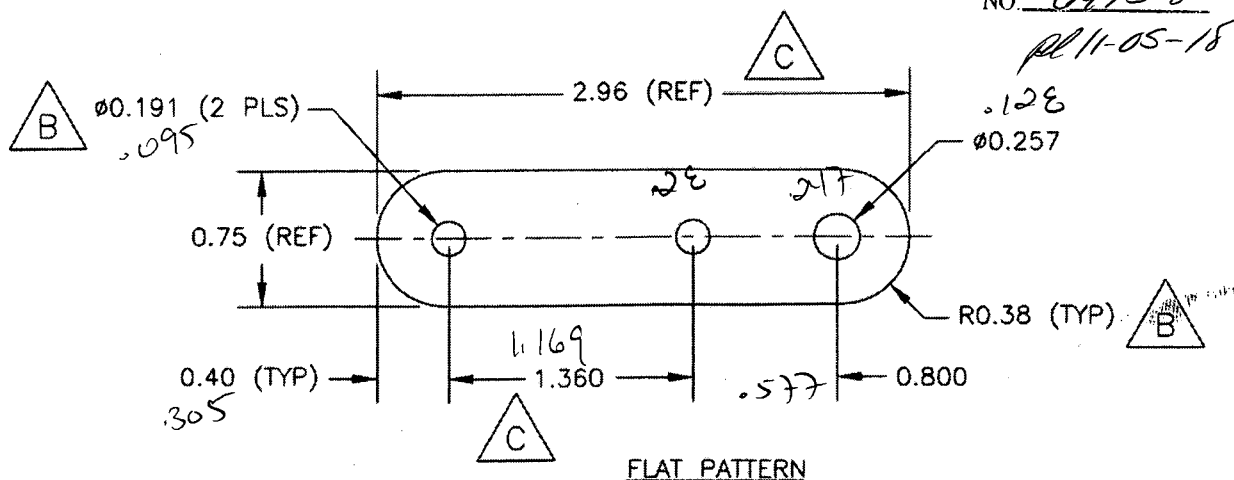
RELEASED
00 05 02



BENT DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69758

11-05-18



MATERIAL: AISI 304/316 SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

Copyright © 1992 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries